

Work Order ID 115512

April-02-14 *11:15:49 AM

115512

Page 1

Item ID: D3391-025 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Aft Tube Assembly

Start Date: 4/02/14 Start Qty: 1.00 *1*

Required Date: 4/16/14 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLS Date: 1404-02 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100

0.00

100

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: H

****REMOVE STEADY REST AND MACHINIG MARKS****

1 φ KC

14-04-03

manil

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

1 φ manil

14/04/06

112

QC5- Inspect part completeness to step on W/O

0.00

112

QC

Memo

0.00

Quality Control

DAS

27

9-89

14/4/14

Work Order ID 115512

April-02-14 11:15:49 AM

115512

Page 2

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 4/02/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/16/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	HAAS CNC VERTICAL MACHINING #1	0.00							DAS 14 9-89
120									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA 599 Rev: <u>4A</u> & Dwg D3391 Rev: <u>I</u> 2-Deburr								
130	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 14 9-89
130									
QC	Memo	0.00							
Quality Control									
140	QC8- Inspect parts - second check	0.00							DAS 44 9-89
140									14/04/28
QC	Memo	0.00							
Quality Control	***INSPECT INSIDE BORE***								

Work Order ID 115512

April-02-14 11:15:49 AM

115512

Page 3

Item ID: D3391-025 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Tube Assembly
 Start Date: 4/02/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/16/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160		0.00							
160	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025								
170		0.00							
170	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

DAS
03
9-83

DD 14-4-29

H-4.15

5/10/41

12-11-41

12-11-41

12-11-41

Work Order ID 115512

April-02-14 11:15:49 AM

115512

Page 4

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Tube Assembly
Start Date: 4/02/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/16/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

180

Skidtubes

Skidtubes

Skidtubes

Memo

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.297" and c'bore as per dwg D3391

6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391.

7-Debur

8- Scribe batch # on fwd end

02/14/08/12

Work Order ID 115512

April-02-14 11:15:49 AM

115512

Page 5

Item ID: D3391-025 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Aft Tube Assembly

Start Date: 4/02/14 Start Qty: 1.00 *1*

Required Date: 4/16/14 Req'd Qty: 1.00 *1*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
200 *200* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
210 *210* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00							

DAS
03
9-89

OK 14/05/14

14-5-14

Work Order ID 115512

April-02-14 11:15:49 AM

115512

Page 6

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 4/02/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/16/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Skidtubes	0.00							
220									
Skidtubes	Memo	0.00							
Skidtubes	1- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <u>129127</u> exp. date: <u>14/12/30</u> cure time 12hfs as per QSI0015								
	2- Grind crossbolts flush								
	3- Back drill using #9 drill								
	4- Touchup Magnabond								
	5- Deburr								
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									

02/14/05/14

02/14/05/15

SP
14/5/15



Work Order ID 115512

April-02-14 11:15:49 AM

115512

Page 7

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 4/02/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/16/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
235	Pressure Wash per QSI005 4.3	0.00							
235									
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
240									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>2:40</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>3:10</u>								
250	QC3- Inspect Part Finish	0.00							
250									
QC	Memo	0.00							
Quality Control									

1 76145-26
1 Ø 14-7-16
11 6 all 11/07/12

Work Order ID 115512

April-02-14 11:15:49 AM

115512

Page 8

Item ID: D3391-025 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Aft Tube Assembly

Start Date: 4/02/14 Start Qty: 1.00 *1*

Required Date: 4/16/14 Req'd Qty: 1.00 *1*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	HandFinishing	0.00							
260	HandFinish	0.00							
Hand Finishing	<p>Memo</p> <p>1-Install inserts as per Dwg D3391</p> <p>2-Install Aft Cap as per Dwg D3391</p> <p>A/ R Sikaflex-241/-291 <u>M129457</u></p> <p>Sikaflex expiry date: <u>1411</u></p> <p>3- INSTALL WEARPLATES AS PER DWG</p>								
270	QC5- Inspect part completeness to step on W/O	0.00							
270	QC	0.00							
Quality Control	Memo								
280	Identify as per dwg & Stock Location: <u>w/o</u>	0.00							
280	Packaging	0.00							
Packaging	Memo								

DAS
27
9-8

4/10/17

0412-742-043 / B14905

11 1 1407/17

11 1 1407/17

April-02-14 11:15:49 AM

Page 9

MLJ 14-07-18

14.7 ft

Picklist Print

April-02-14 11:15:52 AM

Page 1

Work Order ID: 115512

115512

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-047		Manufactured	No			260	Each	18.0000	1	1			
D4095-047									**				
Wearpad Assembly													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					FP001			18					
					102241			2					
					108289			16					
D4095-049		Manufactured	No			260	Each	13.0000	1	1			
D4095-049									**				
Wearpad Assembly													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					FP001			12					
					109670			12					
					FP002			1					
					102216			1					
D6014-090		Manufactured	No			100	Each	69.0000	1	1			
D6014-090									**				
ALUMINUM EXTRUSION													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					LG003			69					
					79742			17					
					86063			52					

Picklist Print

April-02-14 11:15:52 AM

Page 2

Work Order ID: 115512

115512

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

300.0000

4

4

D3670-4-200

Bushing

DC 14/05/14

Location

Loc Qty

Loc Code

FG

10

87709

10

LG001

290

103880

39

109108

242

96240

9

D2646

Manufactured No

270

Each

75.0000

1

1

D2646

Aft Cap

14/07/14

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

71

103306

14

107857

1

110816

18

113830

38

XL

April-02-14 11:15:52 AM

Shop Packet Print

Page 2

Picklist Print

April-02-14 11:15:52 AM

Page 3

Work Order ID: 115512

115512

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270

Each

1,420.000

2

2

D3672-1

Phenolic Washer

ll 11/03/17

Location

Loc Qty

Loc Code

FG

10

85222

10

ST060

1410

103845

4

112218

500

113581

500

93886

224

99099

182

yz

ALS4-1032-130

AELS4-1032-130 Purchased

No

260

Each

9,937.000

14

14

AI S4-1032-130

Rivnut

ll 11/03/17

Location

Loc Qty

Loc Code

FP001

9832

M128649

9832

yz

ST279

48

M128211

48

st510

57

M126109

57

April-02-14 11:15:52 AM

Shop Packet Print

Page 3

Picklist Print

April-02-14 11:15:52 AM

Page 4

Work Order ID: 115512

115512

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

AELS8-1032-225

Purchased

No

270

Each

1,490.000

8

8

AI S4-1032-225

Rivnut

ll 1107117

Location

Loc Qty

Loc Code

FG

30

M127028

30

FP001

1000

M128649

1000

ST280

426

M127028

10

M128179

416

st555

34

M127092

34

x8

AN3C4A

Purchased

No

270

Each

2,208.000

6

6

AN3C4A

Bolt

ll 1107117

Location

Loc Qty

Loc Code

FG

20

122814

20

ST350/513

1000

M128606

1000

ST512

3

124221

3

ST513

1185

125388

122

M127410

1

M127832

62

M128634

1000

M128879

v6

April-02-14 11:15:52 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

DART AEROSPACE LTD		Work Order: 115512
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: I	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

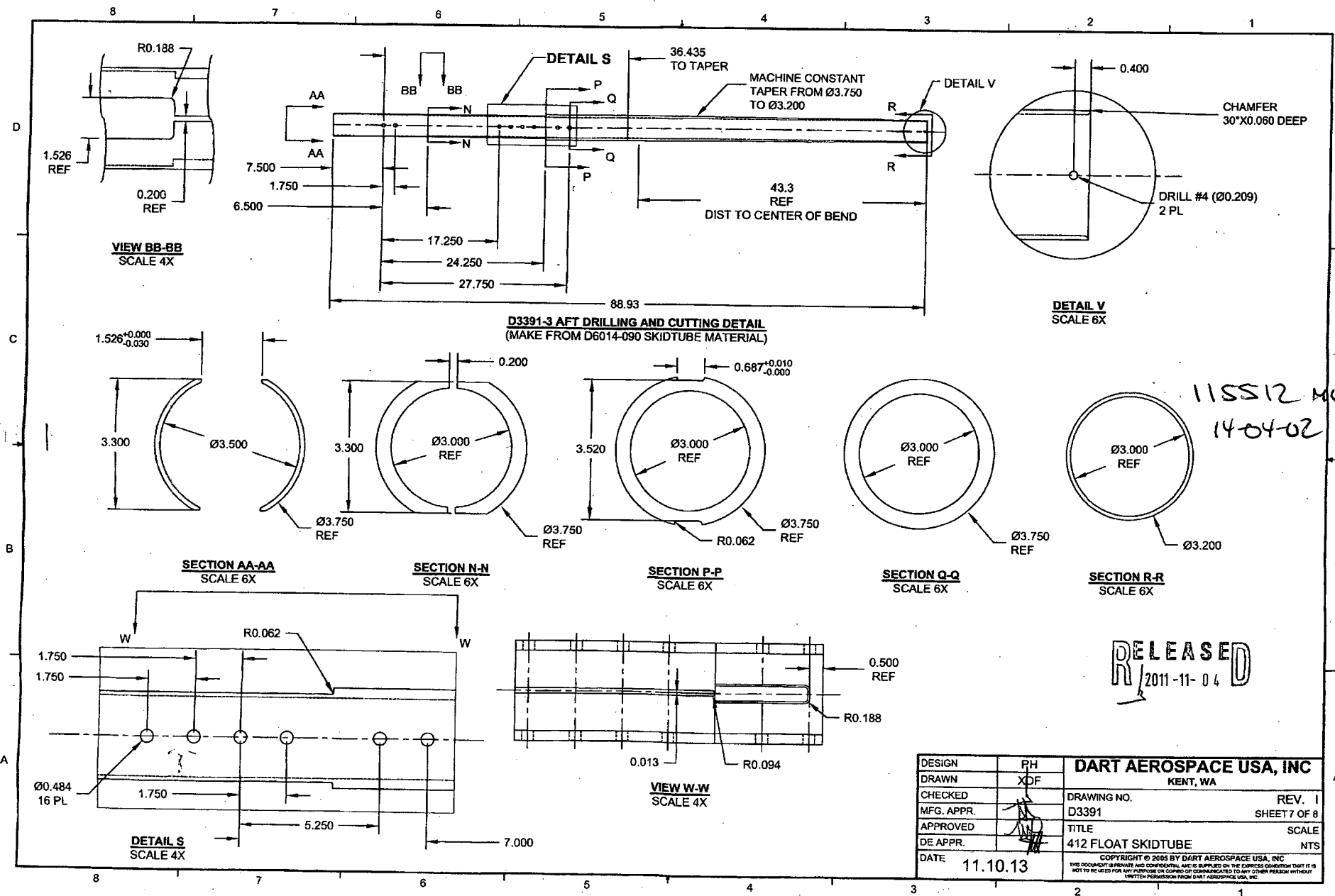
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	✓		tape	LG-25
3.500	+/-0.010	3.504	✓		Vern	CWC-08
Ø3.200	+/-0.010	3.201	✓		"	
Ø3.750	+/-0.010	3.750	✓		"	
30° x 0.060 chamfer	+/-0.010	30° x .060	✓		"	
88.93	+/-0.030	88.93	✓		tape	LG-25

Measured by: mmr	Date: 14/04/06
Audited by:	Date:

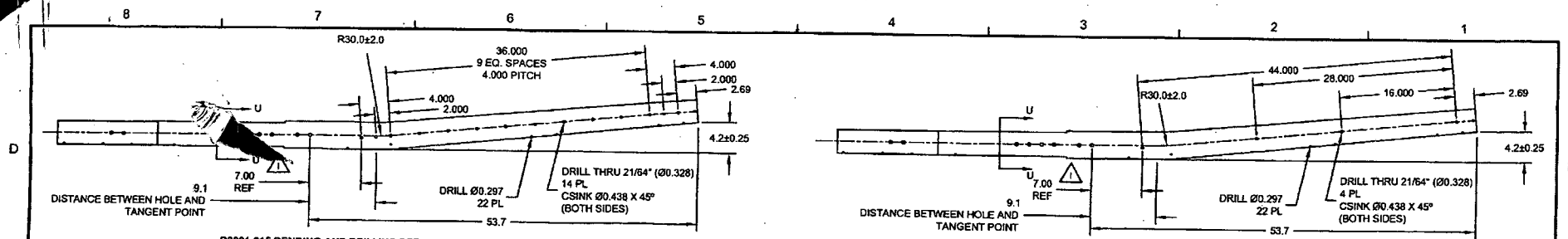
HAAS Section						
1.526	+0.000/-0.030	1.507	✓		Vern	ML-06
7.500	+/-0.010	7.500	✓		"	
27.750	+/-0.010	27.750	✓		M-tape	ML-08
31.750	+/-0.010	31.750	✓		"	
35.250	+/-0.010	35.250	✓		"	
3.300	+/-0.010	3.297	✓		Vern	ML-06
0.200	+/-0.010	.200	✓		"	
3.520	+/-0.010	3.518	✓		"	
0.687	+0.010/-0.000	.690	✓		"	
R0.062	+/-0.010	R.062	✓		R-L	
Ø0.484	+0.005/-0.001	Ø.485	✓		Vern	ML-06

Measured by: mmr	Date: 14/04/27
Audited by: FK	Date: 14/04/28

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	

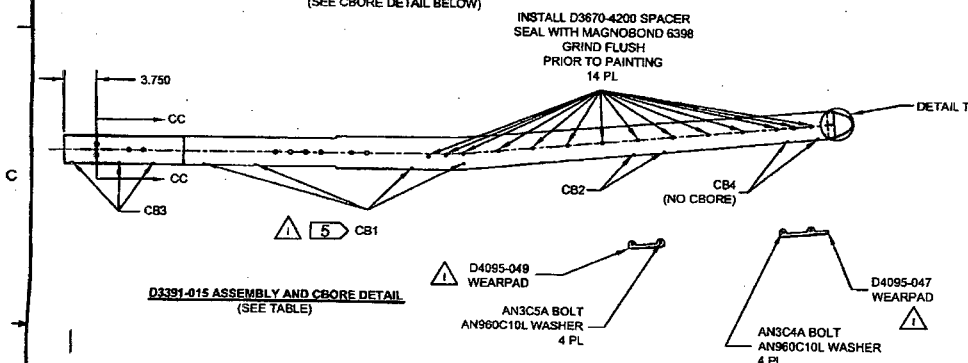


DESIGN	RH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL OR OTHER PURPOSE WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

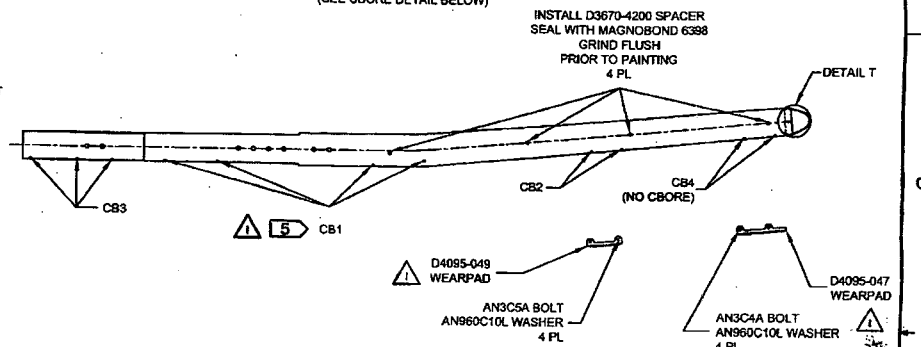


D3391-015 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)



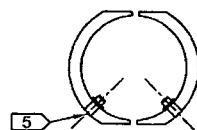
D3391-015 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)



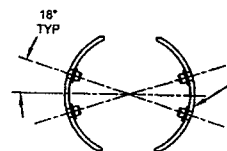
D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

D3391-015/025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D2646	AFT CAP
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
1	1	D4095-049	WEARPAD
1	1	D4095-047	WEARPAD
1	1	D6014-030	AFT TUBE
14	14	AELS-1032-130	INSERT
8	8	AELS-1032-225	INSERT
4	4	AL54-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

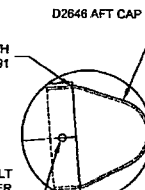


SECTION U-U
SCALE 3X



SECTION CC-CC
SCALE 3X

DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT
4 PL



DETAIL T
SCALE 4X

RELEASED
2011-11-04

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY	QTY	CBORE	P/N
D3391-015	D3391-025			
CB1	8	8	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.43 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	<small> COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS BLANKED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. </small>	

